5/20

DART AEROSPACE LTD

Work Ørder: 22970A

Description: Wearplate

Part Number: D2577-5

Dwg: D2577 Rev. E

Qty: 50 24

Page 1 of 1

Step	Location	Procedure	Ву	Date	Qty
1	DC	Issue Traveller	KI	DC /	~
		Dwg not required	(X [05.04.13	50
2	PG	Issue P/O: 260 768 8	0		
		Email or Ship DXF file to vendor			
		Laser Cut per Dwg D2577 flat pattern D2577-5	V		8
		Material release note required	u	05-04-13	20
3	RG	Receive and Inspect for transit damage	11		
		Ensure that material release note is attached	CZ	05/05/05	50
4	QC6	Inspect dimensions per template D2577-5T1	2.0	05/05/25	50
			m	05/05/03	20
5	GB	Deburr if necessary NA	nul	1/1/-	50
			mo	05/05/25	30
6	GB	Form on brake using DT8155 and DT8179 as per Dwg D2577		1 /2	15
		E	35	05/28/30	2
7	GB	Form joggle using DT8157 as per Dwg D2577	-1	1.122	20
	005	Identify as D2577-5	20	02/08/30	2
8	QC5	Inspect work to Step 7	//	US-08 30	24
_		D 1 0 10 (D (10 5 0) 00 00 10	1	02:00 20	C 1
9	FP	Powder Coat Grey (Ref.4.3.5.6) per QSI 005 4.3	m	05 10 05	14
10	QC3	Jacquet Dawder Cost	11/2	0) 1000	
10	QCS	Inspect Powder Coat	4	\$.0.06	24
11	FP	Identify and Stock		0000	
5.50		identify and Stock	RC	051006	201
12	AC		/		
VIDE:	8.045	Cost / part / 8, / Z	Suc	05-10+11	24
13	DC	Close W/O 17.76		4 4	-
		Inspect Level 21	10	05/10/11	24

Rev	Date	Change	Revised By	Approved
Α	96.08.20	New Issue	NAME OF TAXABLE PARTY.	
В	98.04.15	Changed finish detail, changed forming sub-contractor	KB	
С	99.02.02	Added inspection levels, Jig numbers	DM	
D	99.03.25	Added Joggle	DM -	Tribs
E	00.10.02	Rev.E dwg	EC	0
F	02.09.24	Re-format	KJ RF	4

RELEASED

P70

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector			
Blo Blo Blo										
							200			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
	OTED	Description of NC	Verification Approva	Approval	Approval					
DATE STEP		Section A			Sign & Date	Section C	Design Mgr	QC Inspector		
05-58-30	7	Toggle gress to much in the brake squashing the material	Prier	Scrape destray	2 05-06-30	05-08-30	VB 04742	05-08-30		
						×				

Part No:	PAR #:	Fault Category:	NCR:	Yes No DQA:	Date: 05/0///
NOTE: Date & initial all entries				QA: N/C Closed:	Date:

Job Costing Report

Dart Aerospace Ltd. Hawkesbury

Apr 11, 2005 07:31 am

Work Order No	: 0022970 4
Project Name	: D2577-5
Project For	: WK520
ex- 1- condition make the	Company of the Compan

Work Order Type : Main Main WO Number :

House Part Number : D2577-5 Description : Wearplate, Centre

Manufactured : Yes

Amount Req'd: 50
Amount Done: 0
Start Date: 04-08-05 Est Finish Date : 05-15-05

Act Finish Date : Drawings Reqd : No Ok for Approval :

Approval Rec'd :

Department Code:

Burden Flags : NNNNNNN WO Status : Open

Invoice State : Not Invoiced

Invoice Date : Invoice Number :

Invoice Amount: 0.00

Order Entry No :

OE Value 0.00

Est Mark Up : 0.000% Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours		0.00	0.00	2.22	
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
overHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
	========	========	======		
Burden	: 0.00	0.00	0.00		16C
	========	=======	======		440
Total Cost	: 0.00	0.00	0.00		TH (2.2)
Mark up	: 0.000	0.000	An .		THE ROLL INVESTIGATES
Selling Cost	: 0.00	0.00			
					cif4Delx

Estimated Actual Labour Hrs/Amount Done : 0.00 0.00 Profits/(Loss) 0.00 0.00

P30529ME003 2003/06/02 2003/06/08 2003/		ALATUNIA DAREL LINCORP. 105 Wesi St., Sault Ste. Marie, Ontario, Canada, P6A 7B4		
WILKINGON A DIVISION OF PRESENTACO INC SILE STORM OF PRESENTACO INC SILE SOUTH MAST VARIES STORM OF PRESENTACION OF PRESENTACIO INC SILE SOUTH MAST VARIES S		P30529HE003 2003/06/02 2003/09/08 19201 08 109 109 109 109 109 109 109 109 109 109		
CINCAR SECRECATION CINCAR SECRECATION CINCAR SECRECATION CONTROL STREET STREET - CARRON - ARTH A559 TYPE B 198) . CS - MATTE - P & CIL ACCOUNT AND WITH THE SOURCE CONTROL ACCOUNT OF CAUSE & NO COIL CONTROL OF CAUSE OF CAUSE ACCEPTABLE - (AIM FOR LIGHT RIDE OF CAUSE & NO COIL EARLY) . (FRATABLE CRITICAL) EARLY DESCRIPTION - (AIM FOR LIGHT RIDE OF CAUSE & NO COIL CONTROL OF CAUSE		CHARGETO CUSTOMER NAME & AUGUST	-744130 40	5003
CINCAR SECRECATION CINCAR SECRECATION CINCAR SECRECATION CONTROL STREET STREET - CARRON - ARTH A559 TYPE B 198) . CS - MATTE - P & CIL ACCOUNT AND WITH THE SOURCE CONTROL ACCOUNT OF CAUSE & NO COIL CONTROL OF CAUSE OF CAUSE ACCEPTABLE - (AIM FOR LIGHT RIDE OF CAUSE & NO COIL EARLY) . (FRATABLE CRITICAL) EARLY DESCRIPTION - (AIM FOR LIGHT RIDE OF CAUSE & NO COIL CONTROL OF CAUSE	9	888 SOUTH EAST MARINE DRIVE	MILL TEST REPORT	rs
COURT SECONDARY STEELS SHEET - CARBON - ARTH A569 TYPE B 198) . CS - MATTE - P S CIL SERVING ACCORDANCE WITH COMMUNICATION OF COURT SERVING ACCORDANCE WITH ACCOR	a.	VANCOUVER BRITISH COLUMBIA NEW WESTMINETER BRITISH COLUMBIA	ALGONA STAFL (NC. HEREN CENT	TURB
HOT ROLLAND STREEL SKIRET - CARBON - ARTH A559 TYPE B 198) . CG - MATTE - P G CIL SKRAKS) - (FLATMESS CRITICAL) - (AIM FOR LIGHT SIDE OF GAUGE & NO COIL REMANDELLAND STREEL SKIRET - CARBON - ARTH A559 TYPE B 198) . CG - MATTE - P G CIL SKRAKS) - (FLATMESS CRITICAL) - (AIM FOR LIGHT SIDE OF GAUGE & NO COIL H. HELDERDY HOMEN GENERAL CONTAINS REPORT REQUIRED COVERED GORNOLAR COVERED GORNOLAR COVERED GORNOLAR THE BLIZE SAME AND AND AS A SELECT STREET STREET STREET SAME ACCOUNTY AND AS A SELECT STREET SAME AS A SELECT SAME	٥.		MARIE AND TESTED OF METODANA	STE WHYS
EAX SM ATTN M ELTAS 604 301 3244 "MUST SHIP PAPERWRAPPED ON THE STATE OF THE PAPERWRAPPED ON THE PARTY AND A STATE AND A STA	8	HOT ROLLED STEEL SHEET - CARBON - ASTE A559 TYPE B 1981 - CG LANGE B 5 CT	HEREIN ALCOMPANDED INTER PA	MARKEN .
EAX SM ATTN M ELTAS 604 301 3244 "MUST SHIP PAPERWRAPPED ON THE STATE OF THE PAPERWRAPPED ON THE PARTY AND A STATE AND A STA		BREAKS) - (FLATNESS CRITICAL - (AIM FOR LIGHT SIDE OF GAUGE & NO COIL	ACCREDITATION OF HORSE GLIDE AS CONTADIED IN THE COMPANY	ASCOROL
PAN ATTW M ELIAS 604 301 3244 "MUST SHIP PAPERWRAPPED ON HER PAN ATTW M ELIAS 604 301 3244 "MUST SHIP PAPERWRAPPED ON HER PAN ATTW M ELIAS 604 301 3244 "MUST SHIP PAPERWRAPPED ON HER PAN ATTW M ELIAS 604 301 3244 "MUST SHIP PAPERWRAPPED ON HER PAN ATTW M ELIAS 604 301 3244 "MUST SHIP PAPERWRAPPED ON HER PAN ATTW M ELIAS 604 301 3244 "MUST SHIP PAPERWRAPPED ON HER PAN ATTW M ELIAS 604 301 3244 "MUST SHIP PAPERWRAPPED ON HER PAN ATTW M ELIAS 604 301 3244 "MUST SHIP PAPERWRAPPED ON HER PAN ATTW M ELIAS AND ASSISTANCE OF THE MILL WITH MARKET SHOWN AND ASSISTANCE OF THE MILL WAS	ž	A THE PARTY OF THE		
PAN ATTW M ELIAS 604 301 3244 "MUST SHIP PAPERWRAPPED ON HER PAN ATTW M ELIAS 604 301 3244 "MUST SHIP PAPERWRAPPED ON HER PAN ATTW M ELIAS 604 301 3244 "MUST SHIP PAPERWRAPPED ON HER PAN ATTW M ELIAS 604 301 3244 "MUST SHIP PAPERWRAPPED ON HER PAN ATTW M ELIAS 604 301 3244 "MUST SHIP PAPERWRAPPED ON HER PAN ATTW M ELIAS 604 301 3244 "MUST SHIP PAPERWRAPPED ON HER PAN ATTW M ELIAS 604 301 3244 "MUST SHIP PAPERWRAPPED ON HER PAN ATTW M ELIAS 604 301 3244 "MUST SHIP PAPERWRAPPED ON HER PAN ATTW M ELIAS AND ASSISTANCE OF THE MILL WITH MARKET SHOWN AND ASSISTANCE OF THE MILL WAS			** ** ** *	
TOURED CONDUCTOR CHEMICAL ANALYSIS REFORT REQUIRED CHI ELECTRICAL FANELS CUSTOMER ITEM I CUR ITEM 001 DIMERSIONS .059 X 48 X COIL COIL NOT HERETOLOGICAL PLANELS CUSTOMER ITEM I CUR ITEM 001 DIMERSIONS .059 X 48 X COIL COIL NOTE: SECOND CONDUCTOR SECOND CONTROL C		DIPMEMILYTARY INSTAUCTIONS		
THE RESTRICT AND PERSONS AND ACTION OF THE RESTRICT AND ACTION OF THE RESTR		FAX SW ATTW M WELTAS SDA 307 2244 HATTET GATE DARROWS AND	THIS MILL TEST ABOUT MAY NOT	7 42
CHENICAL ANALYSIS REPORT REQUIRED CHY ELECTRICAL FANELS CUSTOMER ITEM I CUR ITEM 001 DIMENSIONS .059 X 48 X COIL COIL NO. WEIGHT NO. WEIGHT COIL NO.		COVERED COMBOLA ON	MRITTERS APPROVAL OF ALCOMAS	TELLING
CUSTOMER ITEM I CURITEM 001 DIMENSIONS .059 X 48 X COIL COIL WEIGHT SHIPPED ************* COIL WEIGHT SHIPPED ********* COIL WEIGHT SHIPPED ******* NO. WEIGHT SHIPPED ***** NO. WEIGHT SHIPPED **** NO. WEIGHT SHIPPED *** NO. WEIGHT SHIPPED ** NO. WEIGHT SHIPPED *** NO. WEIGHT SHIPPED *** NO. WEIGHT SHIPPED ** NO. WEIGHT NO. WEIGHT SHIPPED ** NO. WEIGHT NO. WEIGHT SHIPPED ** NO. WEIGHT SHIPPED ** NO. WEIGHT NO. WEIGHT SHIPPED ** NO. WEIGHT NO. WEIGHT SHIPPED ** NO. WEIGHT NO. WEIGHT SHIPPED **		ON THE PROPERTY OF THE PARTY OF	NOT THE INTENDED SECTIVER, MEA	SE CALL
CUSTOMER ITEM I OUR ITEM 001 DIMENSIONS .059 X 48 X COIL COIL NO. WEIGHT COIL NUMBER HEAT PIECES 24290 SALES SESSE .04 .26 .006 .005 .02 .02 .01 .01 .00 .029 C.005< .008 TI SN N DOOS 7 THE BEST REQUITS AND TALUES EPORTED HEREIN INDICATE COLLY THAT () THE PRATICULAR FOR WHICH THES CERTIFICATE MASKET AND MANUMENTS AND DEPOCATION OF SURESING AREN CORPORABLE FOR WHICH THES CERTIFICATE MASKET AND MANUMENTS AND DEPOCATION OF SURESING AREN CORPORABLE FOR WHICH THES CERTIFICATE MASKET AND MANUMENTS AND DEPOCATION OF SURESING AREN CORPORABLE FOR WHICH THES CERTIFICATE MASKET LISS MANUMENTS		AUST	OH METHOD OF DISPOSAL OF DOCU	HOST
CUSTOMER ITEM I OUR ITEM 001 DIMENSIONS .059 X 48 X COIL COIL NO. WEIGHT COIL NO. WEIGHT SALES SESSED .02 PIECES 24290 WEAT PIECES 24290 HEAT PIECES 24290 HEAT C NW P S SI CR NI CU NO AL PROPERTIES TIES TO ALL SN NI CONSTRUCTION OF THE SILE O		SHE ELECTRICAL PANELS		
CUSTOMER ITEM I OUR ITEM 001 DIMENSIONS .059 X 48 X COIL COIL NO. WEIGHT COIL NO. WEIGHT STATES SET SET STATES ARE WEIGHT STATES ARE WEIGHT STATES ARE WEIGHT STATES ARE RECOMPONENT IN SET		******************************	* * * * * * * * *	
COIL NUMBER HEAT PIXCES 23170 9341888 5653B-52 1 24290 ***WARNING*** THE TEST RESULTS AND VALUES REPORTED HEREIN INDEXATE CREY HEAT (1) THE PREVENCIAL AND CAPTURES OF SUCKISTED AREN CORPORABLES THE MISSIAN MEDICAL TEST SECRETARIS TO THE PROPERTIES OF SUCKISTED AREN CORPORABLES THE MISSIAN MEDICAL TEST SECRETARIS THE MISSIAN MEDICAL AND SECRETARIS OF SUCKISTED AREN CORPORABLES THE MISSIAN MEDICAL TEST SECRETARIS THE MISSIAN MEDICAL TEST SECRETARIS THE MISSIAN MEDICAL TEST SECRETARIS AND DEPOSITION OF MEDICAL TEST SECRETARIS AND DEPOSITION OF MEDICAL TEST SECRETARIS AND DEPOSITION OF MEDICAL AND CORPORABLES THE MISSIAN MEDICAL TEST SECRETARIS AND DEPOSITION OF MEDICAL TEST SECRETARIS AND DEPOSITION OF MEDICAL AND CORPORABLES THE MISSIAN MEDICAL TEST SECRETARIS AND DEPOSITION OF MEDICAL TEST SECRETARIS AND DEPOSITION OF MEDICAL AND CORPORABLES THE MISSIAN MEDICAL TEST SECRETARIS AND DEPOSITION OF MEDICAL TEST SECRETARIS AND DEPOS		All Completions Treeses		C. 146 St.)
NUMBER S653B-02 PIECES 23170 S141888 S653B-52 PIECES 24290 WEIGHT S653B-02 PIECES 23170 S141888 S653B-52 PIECES 24290 WEIGHT S653B-02 PIECES 24290 WEIGHT S653B-02 PIECES 24290 WEIGHT S653B-52 PIECES 24290 WEIGHT		MATTE		
3341882 5653B-02 1 23170 9341888 5653B-52 1 24290 WHAT C MY P S SI CR MI CU MO AL CB V B TI SN N 5653B .04 .26 .006 .005 .02 .02 .01 .01 .00 .029 < .005< .008		NUMBER HEAT PIECES "SAULT COLL NO. WEIGH	T	
WERT C MW P S SI CR NI CU MO AL CB V B TI SN N 5653B .04 .26 .006 .005 .02 .02 .01 .11 .00 .029 < .005<.008 < .008 D 005q 7 bya L/m; THE TEST RESULTS ARD VALUES REPORTED HEREIN INDICATE CALLY THAT (1) THE PRINTICULAR STREE, FOR WHICH THEN CERTIFICATE IS ASSET HER MINISTERS OF SICKISTERS OF SUCKISTERS OF		9341882 5653B-02 1 23170 9341888 FFETT PIECES	d	
Section of the test results and values reported herein indicate only that (1) thereacticular steel fire which this certificate is asset of the minimum of the certificate of the certificate of the minimum of the certificate of the cert	96	P. T. S. D.		
Obosq 7 690 6	St	BEAT C MV P S ST CP WI CIT WO		20 0
ODOSQ? 690	UD	3039E .04 .26 .006 .005 .02 .02 .01 .01 .00 .029 <.005<.008 <.008 SK	N	
ODOSQ? 690	n S			
Oposq ? 6ga	Ξ			
Oposq 7 6 ya	M			
Oposq 7 6 ya				
Oposq 7 6 ya	×			
Oposq 7 6 ya	- F			
THE TEST RESULTS AND VALUES REPORTED HEREIN INDICATE CHLY THAT (1) THE PARTICULAR STREEL FOR WHICH THIS CERTIFICATE IS INSTEAD MOREINS THE MINIMUM THE PROPERTY AND INTITUDE OF MAINLY SERVICE OF SUCH STREET, ARE IN COMPORABLY WITH THE PROPERTY OF THE PROP	-			
THE TEST RESULTS AND VALUES REPORTED HEREIN INDICATE CHLY THAT (1) THE PARTICULAR STREEL FOR WHICH THIS CERTIFICATE IS INSTEAD MOREINS THE MINIMUM THE PROPERTY AND INTITUDE OF MAINLY SERVICE OF SUCH STREET, ARE IN COMPORABLY WITH THE PROPERTY OF THE PROP	4	0.05.7		
THE TEST RESULTS AND VALUES REPORTED HEREIN INDICATE CHLY THAT (1) THE PARTICULAR STREEL FOR WHICH THIS CERTIFICATE IS INSTEAD MOREINS THE MINIMUM THE PROPERTY AND INTITUDE OF MAINLY SERVICE OF SUCH STREET, ARE IN COMPORABLY WITH THE PROPERTY OF THE PROP	700	I had cross		
THE TEST RESULTS AND VALUES REPORTED HEREIN INDICATE CALLY THAT (1) THE PARTICULAR STREEL FOR WHICH THIS CERTIFICATE IS INSTEAD AND AND ASSTREE AND ANALYSIS AND INTEGRAL PROPERTIES OF SUCKSTEEL AREIN COMPORTANCE WITH THE PARTICULAR STREET AND THE PROPERTY OF THE PARTICULAR STREET AND THE PARTICULAR STRE	1	10 44 Lrm		
	-	SAGE		
UNE INDECATED AND CAN NOT BE BELIED BYON FOR ANY PERPOSE (INCLUDING DESIGN OR CALCULATIONS) AS REPRESENTANOTHS ACTUAL STRENGTH OR SHICK ATEN	97			9
	L	undindriated and can not be belied from for any ferfore (including design or calculations) as representatothe actual strength	HER THAN THE 3 CP SUCH STEEL	

